



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G06131-3G

Job Sheet 171602



Part No: RBW6405G06131-3G

Job Qty: 2 ea

Part Name: Reaction Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/5/18

Job Tracking No:

Due Date: 2/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G06131-3G Rev 3 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/22/18	0.00	0.00	Start Up Small Fab-4		FF
100	Small Fab	2 pcs		2/23/18	0.08	0.13	Small Fab-9		FF
110	QC	2 pcs		2/23/18	0.00	0.00	QC5		SB
130	Packaging	2 pcs		2/23/18	0.00	0.00	Packaging3-2		18-04-23
140	QC21-FG	2 Ea		2/23/18	0.00	0.00	QC21		GA096

Part Op 100 - Assemble as per DWG.

Descriptions: 130 - Identify and Stock

DAS

21

9-80

APR 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G06131-3G-1	Reaction Weldment	2 Ea (1 ea)	90-Start up Operation	5053723
RBW6405G06131-3G-7	Washer	2 Ea (1 ea)	90-Start up Operation	5054757

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6405G06131-3G-1	2	0	0
	RBW6405G06131-3G-7	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



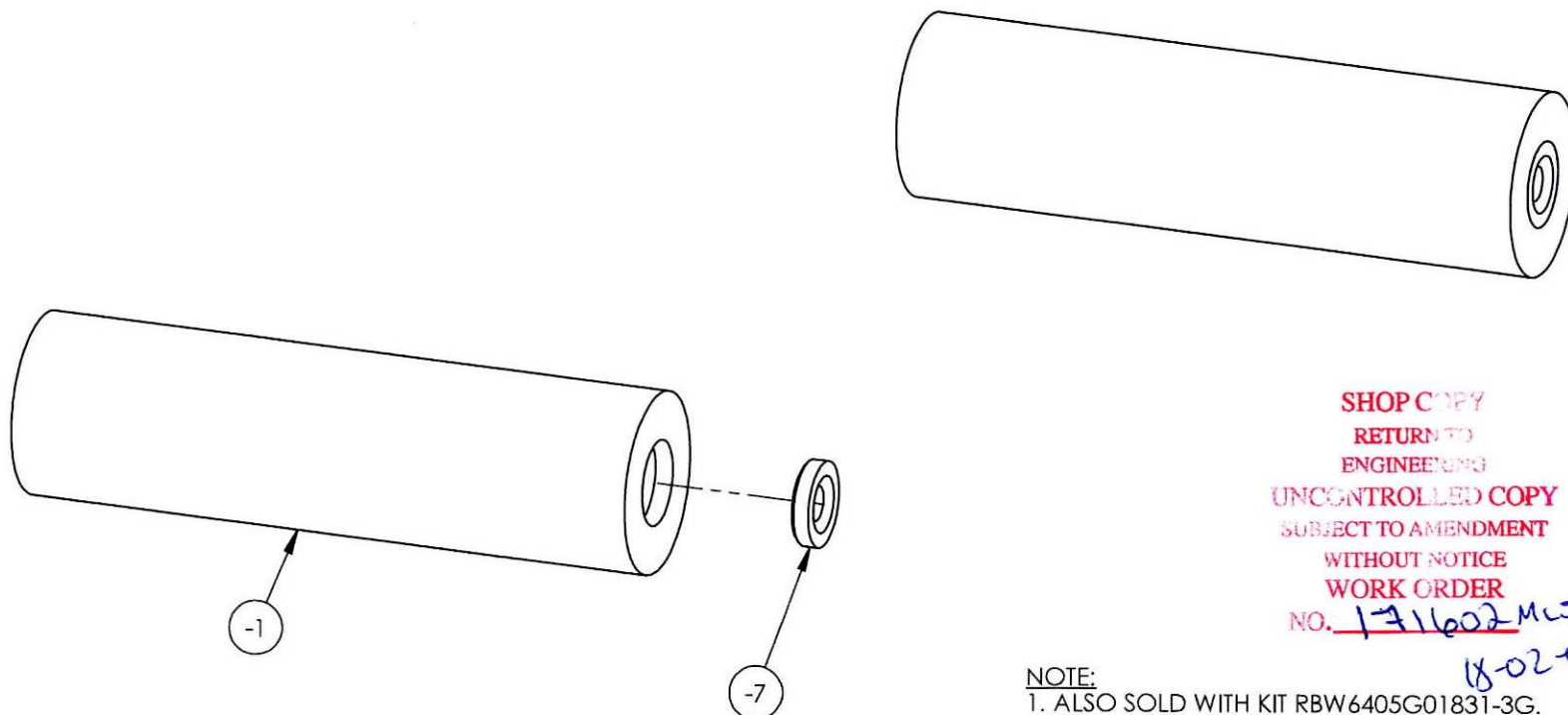
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod. Eng. Coord. ☐		Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		Container No: S064035 Part: RBW6405G06131 - 3G Job No: 171602 Serial No/Batch: S064035 Revision: 3 Inspector:					
Description Work Order De: _____		_____							
_____		_____							
_____		_____							
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pres. ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
_____		_____		_____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		ADDED MISSING Ø1.750 DIMENSION -3, CHANGED NOTE 1, ADDED ASSY DWG.	4/26/2011	RJC	
B		-3 DIMENSION WAS Ø1.50 IS Ø1.501-1.500, -5 DIMENSION WAS Ø1.50 IS Ø1.4996-1.4992.	6/6/2014	DJN	RJC
3	16-0021	UPDATED TO NEW STANDARDS. ADDED REF T/N NOTE. -1 ADDED DIMS Ø.939-.940, .200. ADDED CLEAN UP O.D. AFTER WELDING NOTE. -3 ADDED DIMS Ø1.5, .20. -5 CH'D DIMS WAS Ø.9390-.9400 IS Ø.92. WAS Ø1.4992-1.4996 IS Ø1.497-1.498. CH'D NOTE WAS BORE TO Ø.9400 AFTER WELDING IS BORE TO FINAL DIM AFTER WELDING, SEE -1. -7 CH'D DIM WAS .400 IS (.390). CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	2/5/2016	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 171602 MJS
1802-α

NOTE:

1. ALSO SOLD WITH KIT RBW6405G01831-3G.
2. REF. AGUSTA T/N: 3G6405G06131.

DART AEROSPACE																		
TITLE REACTION ASSY.																		
DWG NO. RBW6405G06131-3G	REV 3																	
<table border="1"> <tr> <td>MAT'L</td> <td rowspan="4"> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓ </td> </tr> <tr> <td>TREAT</td> </tr> <tr> <td>FINISH</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY: CLOUGH</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td>AGUSTA AW139</td> </tr> <tr> <td>SCALE 1:2</td> <td>DATE 3/19/2010 SHEET 1 OF 5</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓	TREAT	FINISH	SPEC	DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR: LINDSAY	USED ON MODEL	APPROVED: GILBERT	AGUSTA AW139	SCALE 1:2	DATE 3/19/2010 SHEET 1 OF 5
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APPROVED: GILBERT	AGUSTA AW139																	
SCALE 1:2	DATE 3/19/2010 SHEET 1 OF 5																	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	REACTION ASSY. WELDMENT			2
	1		-3		TUBE	6061		3
	1		-5		CAP	6061		4
			-7	1	WASHER	O-1		5
	ASSY -1							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
(Faint red stamp: REWORK, DISPOSITION, etc.)				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					